***************************************												
											Page	1
•			Accept				s s	Setup	Start	i 18611161 61	1212 161 1161 1881	•
	77	Date/ <u>0-9-07</u> Date:	Tooling: SPC (Y/N):				. R	Run	Start Stop			
D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	-		•	Insp. Stamp	
Revi C	ision Nbr											
	Memo		0.00 0.00 PD206-581-017	S Oldo	ĺ		*John	( <u>B</u> 6	<u>5 10</u>	-10-04 (G)	1 Pro	
	Pick Kit Memo		0.00				(-6	14	<del>                                    </del>	3u		_
	D206-581-01  Retension Stra 9/7/2010 10/13/2010  Process Pla QC:  D  Rev	10/13/2010 Req'd Qty: 6.00  Process Plan: QC:  Operation Description  Revision Nbr  C  DOCUMENT CONTRO  Memo Photocopy  Pick Kit	D206-581-017  Retension Strap Installation  9/7/2010 Start Qty: 6.00  10/13/2010 Req'd Qty: 6.00  Process Plan: QC: Date:  Operation Description  Revision Nbr C  DOCUMENT CONTROL  Memo Photocopy bluefile & type labels per PP	D206-581-017  Retension Strap Installation  9/7/2010  Start Qty: 6.00  10/13/2010  Req'd Qty: 6.00  Process Plan:  QC:  Date:  Date:  Description  Revision Nbr  C   DOCUMENT CONTROL  Memo Photocopy bluefile & type labels per PPPD206-581-017  Pick Kit  Date:  Document Document Control  Note of the process Plan of the process	D206-581-017  Retension Strap Installation  9/7/2010 Start Qty: 6.00  10/13/2010 Req'd Qty: 6.00  Process Plan:  Date:  Date:  Date:  Date:  SPC (Y/N):  Date:  Doublescription  Revision Nbr  C  DOCUMENT CONTROL  Memo  Photocopy bluefile & type labels per PPPD206-581-017  Pick Kit  D. 0.00  Discription  Discription  Pick Kit  Date:  Doublescription  Doublescript	Date   Operation   Date   Date   Date	D206-581-017  Retension Strap Installation  9/7/2010 Start Qty: 6.00  10/13/2010 Req'd Qty: 6.00  Date:  Process Plan:  QC:  Date:  SPC (Y/N):  Date:  Description  Revision Nbr  C   DOCUMENT CONTROL  Memo Photocopy bluefile & type labels per PPPD206-581-017  Pick Kit  O.00  Pick Kit  O.00  Pick Kit  O.00  Pick Kit  O.00  Pick Kit  O.00	Date   O7, 2010 12:40:32 PM   Date   Security   One   Date   Da	Date   O7, 2010 12:40:32 PM	D206-581-017  Accept	D206-581-017  Accept  Setup Start   Stop   Start   Start   Stop   Start   Start   Start   Start   Stop   Start   Star	D206-581-017  Accept  Setup Start  Stop  9/7/2010 Start Qty: 6.00  10/13/2010 Req'd Qty: 6.00  Cust Item ID: Customer:  Process Plan: QC: Date: SPC (Y/N): Date:  Operation Description Run Hours  Revision Nbr  C  DOCUMENT CONTROL Memo Photocopy bluefile & type labels per PPPD206-581-017  Pick Kit  One  One Pick Kit  One  Pick Kit  One  Document  Accept Stop  Start  Stop  Run Start  Stop  Accept Stop  Start  Stop  William  Stop  Start  William  Start  Stop  William  Start  Stop  William  Stop  William  Stop  William  Stop  William  Start  Stop  William  Stop  William  Start  William  Stop  William  William  Stop  William  Stop  William  Stop  William  William  Wi

120

QC4- 100% Inspect kits for completeness

0.00



Quality Control

Memo

0.00

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/10/04	# 110	PROCEDURE CHANGE  Missing Parts From Parts List to w/o. ADD Parts to kit  80-004-208 m# 115720 (2) per lit - 5 66  MS24694-552 m+11502 (2) per kit - 5 66	ly	1 4/14/4	12 12		Sololot
ioliola	100	Mon Bom to As Reference.					ि (वे।वेग्

Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed	l <b>:</b>	Date:

NCR:		W	WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	Approval	Approval						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector					
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				***************************************		,							
		. *											
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## Work Order ID 61818

Tuesday, September 07, 2010 12:40:32 PM



Page 2

Item ID:

D206-581-017

Accept

Setup Start

**Revision ID:** 

Item Name:

Retension Strap Installation

**Start Date:** 

9/7/2010

Start Qty: 6.00

Req'd Qty: 6.00 **Required Date:** 10/13/2010

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Stop

Stop



QC:

Date:\_\_\_\_

SPC (Y/N):

0.00

0.00

Set Up/

**Run Hours** 

Tool ID

Date:

Tool # Plan

Code

Reject Accept Oty **Qty** 

Run

Reject Number

Insp. Stamp

Sequence ID/ Work Center ID

130

Packaging Packaging

Packaging

Operation

Description

Identify and pack for shipping as per PPP D206-581-017

Location:

PPP Rev:

QC21- Final Inspection - Work Order Release

0.00

QC Quality Control

140

Memo

0.00

10/10/c. U 10-CO.US

Dart Aerospace I	Ltd
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W/O:			W	ORK ORDER CHANG	EŜ				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Prod Nigr	
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No <b>DQ</b>	<b>\</b> :	Date:	
		esolution:							
NCR:		\	WORK ORI	DER NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC			tion B Verification			Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector

## **Picklist Print**

Tuesday, September 07, 2010 12:40:36 PM

Work Order ID: 61818

Parent Item: D206-581-017

Parent Item Name:

Retension Strap Installation



**Start Date:** 9/7/2010

Start Qty: 6.00

**Required Date: 10/13/2010** 

Required Qty: 6.00

Comments:

Ipp Rev:A New Issue 10-07-16 JLM Verified BY:DD

Component Item II Item Name	D/ Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3031-3 .		Manufactured	No			100	Each	12.0000	2 ;	12		L	
Доор				Location	<u>1</u>	Loc	<u>Oty</u>	Loc Code		562	331	SIN	1011
				ST034			12		<del>-</del>		- 11/2	•	·
					50542 51819		2 10		کے۔	0 SY:	540		
D4104-041		Manufactured	No		31013	100	Each	0.0000		6 <	_//6//~		
Doubler Assembly											222	L	<u></u>
D4105-1		Manufactured	No			100	Each	0.0000		Blak	016	10/1	رادال
Strap CR3243-4-1	AA HII MAAK AIRN IIRAAN NIRN IAAI	Purchased	No			100	Each	0.0000	<b>8</b> ,	48	<del></del>	•	D
Rivet	BB 1911 118811 B181 118881 2187 1881								†	M11)	5708		<u> </u>
MS21042L3		Purchased	No			100	Each	2,103.000	2	12	-		0
Nut				Location	<u>n</u>	Loc	_	Loc Code				<u> </u>	
				ST300	114523		2103 109		_		_		
					114784		1994			n/147	84		
MS24694-S47		Purchased	No			100	Each	0.0000	2	12 0	• /		1
										M	1156.	22/	0/0/5/3

Screw

rospace	Ltd								
		W	ORK ORDER CHANGE	S					
STEP	PRO	OCEDURE CH	ANGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								···	
:	PAR #:	Fault Cat	egory:	NCR:	Yes N	lo DQA:		_ Date: _	
R	esolution:	Dispositi	on:	QA: N	C Clo	sed:		Date: _	
	,	WORK ORE	ER NON-CONFORMA	NCE (I	NCR)				
OTER	Description of NC	Description of NC Corrective Action Se		Section B		Verifica	tion	Approval	Approval
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	I .	-	n & Section C	Chief Eng	QC Inspector	
	STEP	:PAR #: Resolution:  STEP Description of NC	STEP PROCEDURE CHARACTERS PROCEDURE CHARACTERS PAR #: Fault Cate Resolution: Disposition WORK ORD STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE  PROCEDURE CHANGE  PAR #: Fault Category:  Resolution: Disposition:  WORK ORDER NON-CONFORMA  STEP Description of NC Section A Corrective Action Section Section A Corrective Action Description	STEP PROCEDURE CHANGE  PAR #: Fault Category: NCR:  Resolution: Disposition: QA: N/  WORK ORDER NON-CONFORMANCE (I	STEP PROCEDURE CHANGE By  :PAR #: Fault Category: NCR: Yes N  Resolution: Disposition: QA: N/C Clo  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Corrective Action Section B  Initial Action Description Sign &	STEP PROCEDURE CHANGE By Date  :PAR #:Fault Category:NCR: Yes No DQA:  Resolution:Disposition:QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By Date Qty  :PAR #: Fault Category: NCR: Yes No DQA:  Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr  :PAR #:Fault Category:NCR: Yes No DQA:Date:  Resolution:Disposition:QA: N/C Closed:Date:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Section C

NCR:			WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	Approval	Approval						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector					
						4 - 1							

Tuesday, September 07, 2010 12:40:36 PM

Work Order ID: 61818

Parent Item:

D206-581-017

Parent Item Name:

Retension Strap Installation

MS24694-S50

Purchased

No

No



S Screw

NAS1149D0332J

Purchased

1887/8 1884 (1886 1886) 1884 (1881 1881) 1887/8 1884 (1881 1888) 1884 (1888) 1884 (1884)

**Start Date:** 9/7/2010

**Required Date: 10/13/2010** 

Start Qty: 6.00

Required Qty: 6.00

 Loc Oty

 ST289
 146

 115016
 146

100

Each

Each

Loc Code

Loc Code

146.0000

826.0000

M1/6/06

12

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M114884

Dart Ae	rospace Ltd							•
W/O:			WORK ORDER (	CHANGES				
DATE	STEP	PRO	OCEDURE CHANGE	В	y Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
······································								
Part No	:	PAR #:	Fault Category:	NCR: \	es No <b>DQ</b>	<b>A</b> :	Date: _	
	Resolut	ion:	Disposition:	QA; N/	C Closed:		Date: _	
NCR:			WORK ORDER NON-CON	FORMANCE (N	ICR)			

NCR:		\	WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	Approval	Approval						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector					
							į						

### 5.0 **PART LIST**

### D407-581-111/-011 AND D206-581-113/-013/-014/-015/-017 KITS 5.1

Qty -111	Qty -113	Qty -011	Qty -013	Qty -014	Qty -015	Qty -017	Part Number	Description
Х							D407-581-111	PRE-FLIGHT KIT (407)
	Х						D206-581-113	PRE-FLIGHT KIT (206A/B/L/L1/L3/L4)
2		Х					D407-581-011	PRE-FLIGHT STEP KIT, LH/RH (407)
	1		Х				D206-581-013	PRE-FLIGHT STEP KIT, LH (206A/B/L/L1/L3/L4)
	-1		·	Х			D206-581-014	PRE-FLIGHT STEP KIT, RH (206A/B/L/L1/L3/L4)
4	4				Х		D206-581-015	STEP HANDLE KIT
		,				Х	D206-581-017	RETENTION STRAP KIT
						2	D3031-3	LOOP
		1	1	1			D4101-041	PRE-FLIGHT STEP ASSEMBLY
			1				D4102-1	SHIM (206 LH)
				1			D4102-2	SHIM (206 RH)
		1					D4102-3	SHIM (407)
					1		D4103-1	STEP HANDLE
						1	D4104-041	DOUBLER ASSEMBLY
						1	D4105-1	STRAP
						-		
						2	80-004-2D8	INSERT <
					2		80-005-3-8	INSERT
7.		6	6	6			80-005-3-16 .	INSERT
						8	CR3243-4-1	RIVET
						. 2	MS21042L3 '	NUT
						2	MS24694-S47	SCREW
						2	MS24694-S50	SCREW
						. 2	MS24694-S52	SCREW A
	-				2		MS27039-4-11	SCREW
		6	6	6			MS27039-4-14	SCREW
			-			2	NAS1149D0332J	WASHER (or AN960JD10L)
		6	6	6	2		NAS1149D0416J	WASHER (or AN960JD416L)
				_	2		NAS1149D0463J	WASHER (or AN960JD416)

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